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**(54) VALVE SEAT FOR INTERNAL  
COMBUSTION ENGINE**

**(57) Abstract:**

**PURPOSE:** To easily mold a circulating path for cooling liquid and a valve seat having a clad sheet layer and further to more improve cooling performance by the clad sheet layer.

**CONSTITUTION:** A valve seat 16 comprises a cooling groove 17, closing member 18 and a clad sheet layer 19. The cooling groove 17 is drilled in a contact location of an intake valve 6 in a cylinder head 1. The cooling groove 17 is formed in a circular annular shape and opened toward a combustion chamber 2. The cooling groove 17 communicates with a cooling water introducing hole and a cooling water discharge hole 26. The closing member 18 closes an opening end of the cooling groove 17. A circulating path 21 for cooling water is formed between the closing member 18 and a wall surface of the cooling groove 17. The

clad sheet layer 19 is formed by padding in surface of the closing member 18 and a peripheral location of the cooling groove 17 by a laser clad method where metal powder is welded by using irradiation of laser light.

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